

Work Order ID 81426

March-14-12 8:29:05 AM

81426

Page 1


Item ID: D3805-045
 Revision ID:
 Item Name: Wearplate Assembly Aft. Low Gear
 Start Date: 3/14/12 Start Qty: 8.00
 Required Date: 3/20/12 Req'd Qty: 8.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan:  Date:
 QC: Date:

Tooling: Date:
 SPC (Y/N): Date:

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3805	B
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100	0.00
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100

Large Fab

Large Fab

Memo

0.00

1- On D3806-5, fill cut outs with hardcoat welding rod as per dwg D3805
 2059 B Hardcoat Welding Rod
 BATCH#: M120392 → 2059B

2-weld D3806-5 to D3805-5 together as per dwg D3805
 304 S.S. Welding Rod
 BATCH#: M120013

3-Transfer drill holes in bar

CUT BAR TO FINISH SIZE AFTER WELDING HARD COAT

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
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110

QC


Quality Control

Memo

0.00

 R.03.21

 MR/MAL 2012-03-21

10x 

Work Order ID 81426

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Page 2

Item ID: D3805-045
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Start Date: 3/14/12 Start Qty: 8.00
Required Date: 3/20/12 Req'd Qty: 8.00
Reference:

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Cust Item ID:
Customer:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours**

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

8/2/12/22

(H0)

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:15
OVEN TEMPERATURE: 320
FINISH TIME: 1:45

10 BL 12-3-BB.

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

10 X 8 mm 12/03/26

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Page 3

Item ID: D3805-045
Revision ID:
Item Name: Wearplate Assembly Aft. Low Gear
Start Date: 3/14/12 Start Qty: 8.00
Required Date: 3/20/12 Req'd Qty: 8.00
Reference:

Accept

N9000040100

Setup Start ***NS1***
Stop ***NS2***

Cust Item ID:
Customer:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

150

Small Fab

Memo

0.00

Small Fab

1- Bond D3807-5 gasket to inner surface of wearplate using a thin layer of 3m
1300/1300L scotch grip adhesive as per dwg
BATCH: m120954

Ac 12.03.27 (X10)

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

8/12/03/26

(40)

170

Identify as per dwg & Stock Location: FP-1

0.00

170

Packaging

Memo

0.00

Packaging

X10 of 161 12/03/20
counted a measure

Work Order ID 81426

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81426

Page 4

Item ID: D3805-045
Revision ID:
Item Name: Wearplate Assembly Aft. Low Gear
Start Date: 3/14/12 Start Qty: 8.00
Required Date: 3/20/12 Req'd Qty: 8.00
Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/3/29 J
P12-03-28

Picklist Print

March-14-12 8:29:04 AM

Page 1

Work Order ID: 81426

Parent Item: D3805-045

Parent Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 3/14/12

Required Date: 3/20/12

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD IPP Rev:B 09-03-04 rev.a as per dwg
DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-5 Plate		Manufactured	No			100	Each	38.0000	1	8			

79622 x 10

Location	Loc Qty	Loc Code
WA	34	
79568	20	
79622	14	
WA030	4	
75676	2	
78128	2	

(X10) ME/MAL 2012-03-21

D3806-5 Bar		Manufactured	No			100	Each	54.0000	1	8			
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80442 x 10

Location	Loc Qty	Loc Code
WA	50	
79570	30	
80442	20	
WA030	4	
46781	2	
75941	2	

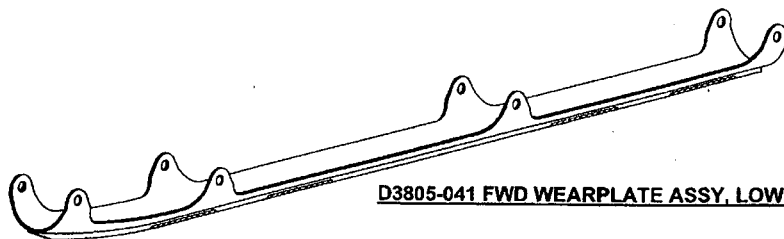
(X10) ME/MAL 2012-03-21

D3807-5 Gasket		Manufactured	No			150	Each	75.0000	1	8			
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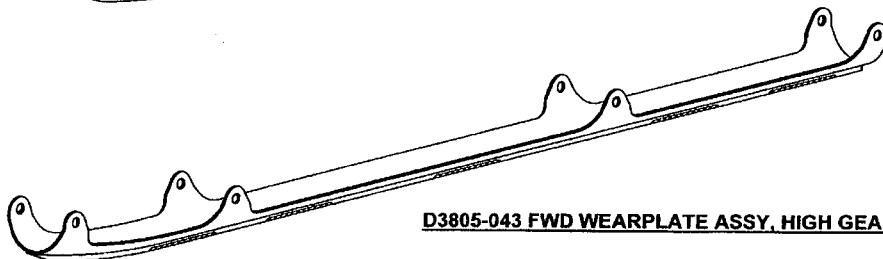
Location	Loc Qty	Loc Code
GA	75	
74944	1	
78132	3	
79572	37	
79626	34	

B 79572 (X10)
AL 12.03.27

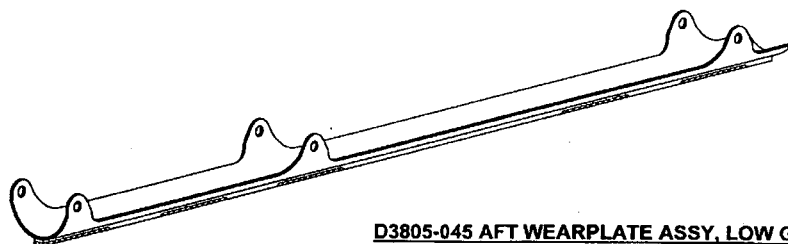
8 7 6 5 4



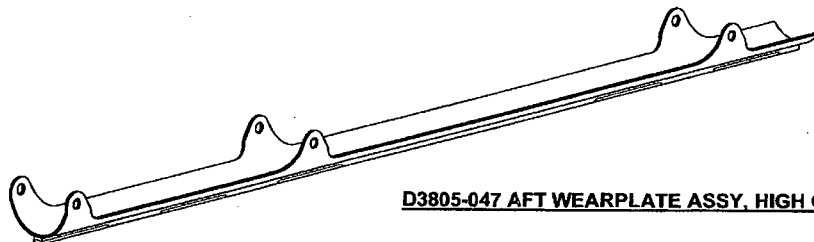
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

8 7 6 5 4

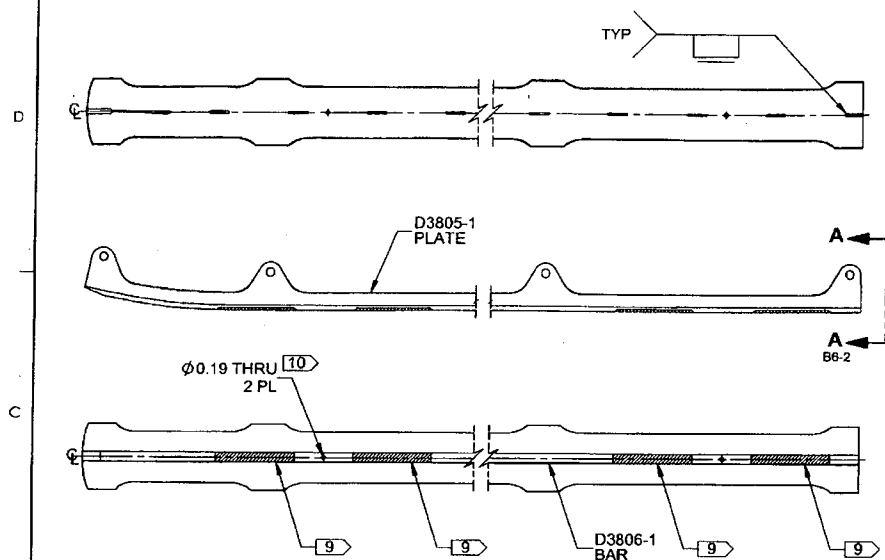
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

1081426

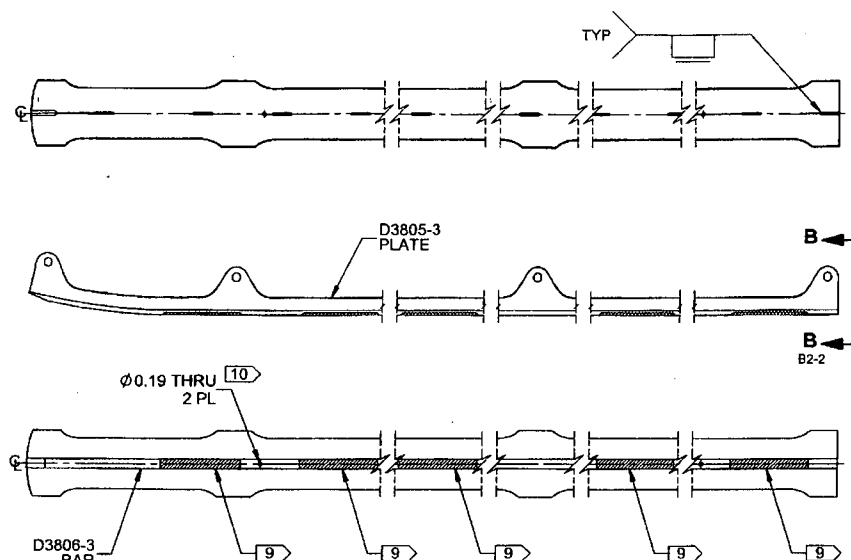
RELEASED
2011-10-03

B	REVISED D3805-1F/3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PART11-108) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>g</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>g</i>	KENT, WA	
CHECKED	<i>g</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>M</i>	D3805	SHEET 1 OF 8
APPROVED	<i>g</i>	TITLE	SCALE
DE APPR.	<i>g</i>	WEARPLATE ASSY	NTS
DATE	11.09.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

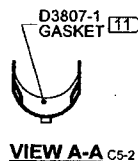
8 7 6 5 4 3 2 1



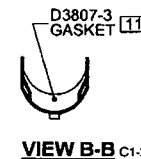
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



VIEW A-A C5-2







VIEW B-B C1-2

RELEASED
2011-10-03

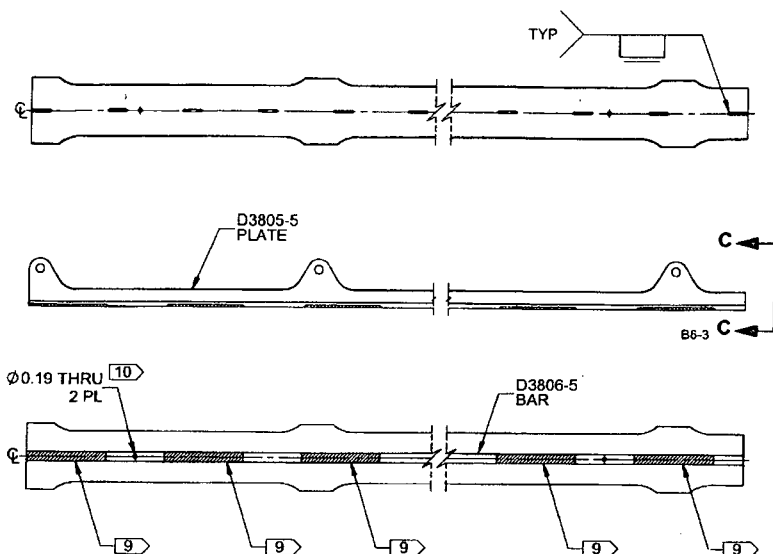
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARD COAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
- 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

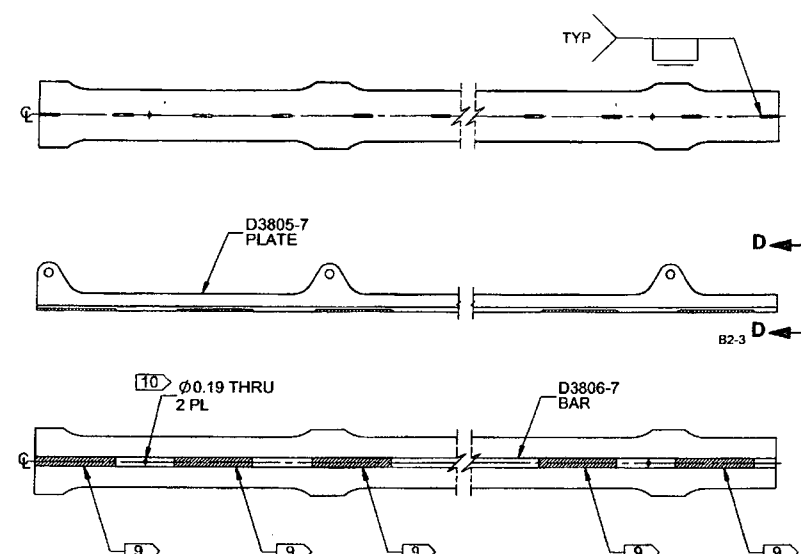
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

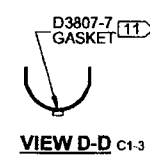
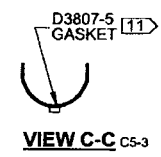
8 7 6 5 4 3 2 1



D3805-045 AFT WEARPLATE ASSY.



D3805-047 AFT WEARPLATE ASSY.



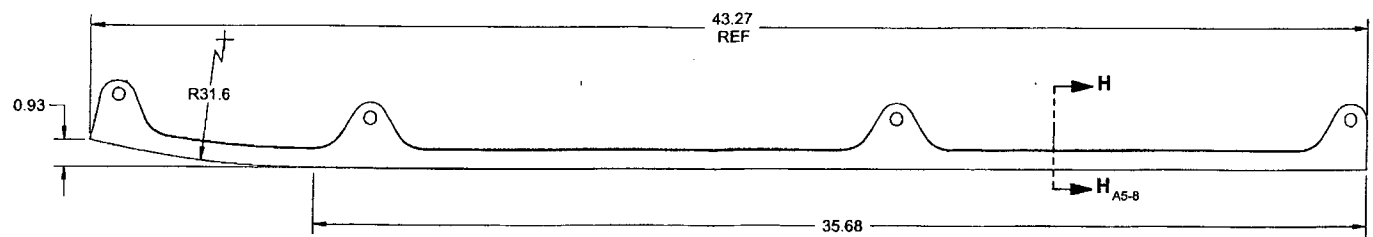
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
- 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

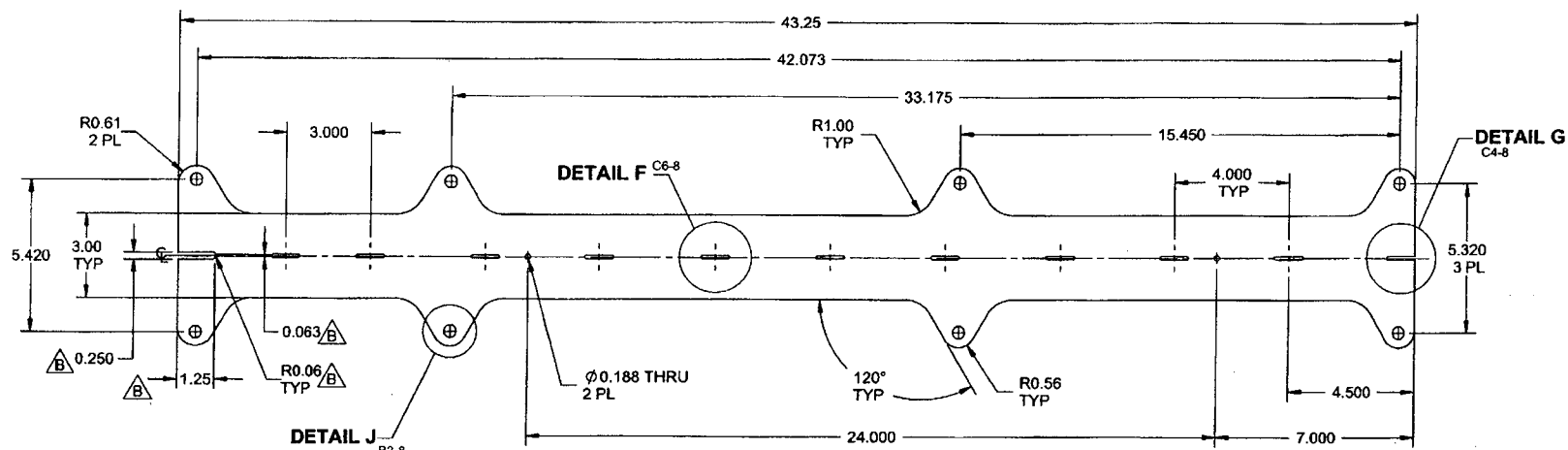
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DRAWN		KENT, WA	
CHECKED		DRAWING NO. D3805	REV. B
MFG. APPR.		TITLE	SHEET 3 OF 8
APPROVED		WEARPLATE ASSY	SCALE
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RELEASED
2011-10-03

8 7 6 5 4 3 2 1



D3805-1 PLATE
(MAKE FROM D3805-1F)



D3805-1F PLATE

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2011-10-03

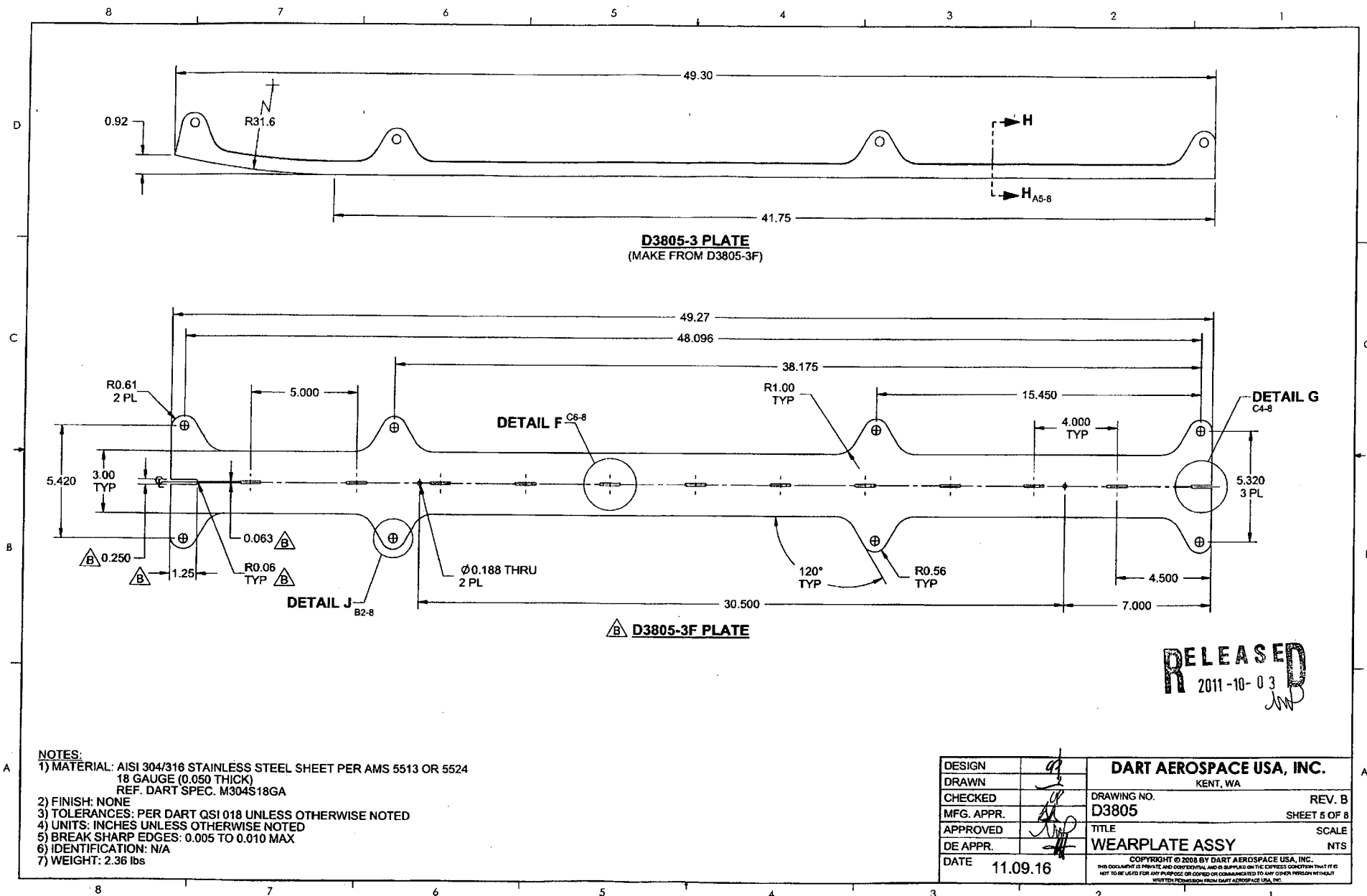
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.11 lbs

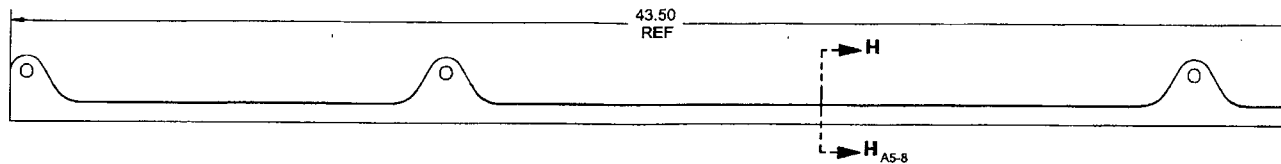
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D3805	REV. B
MFG. APPR.		SHEET 4 OF 8	
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	
DATE	11.09.16	NTS	

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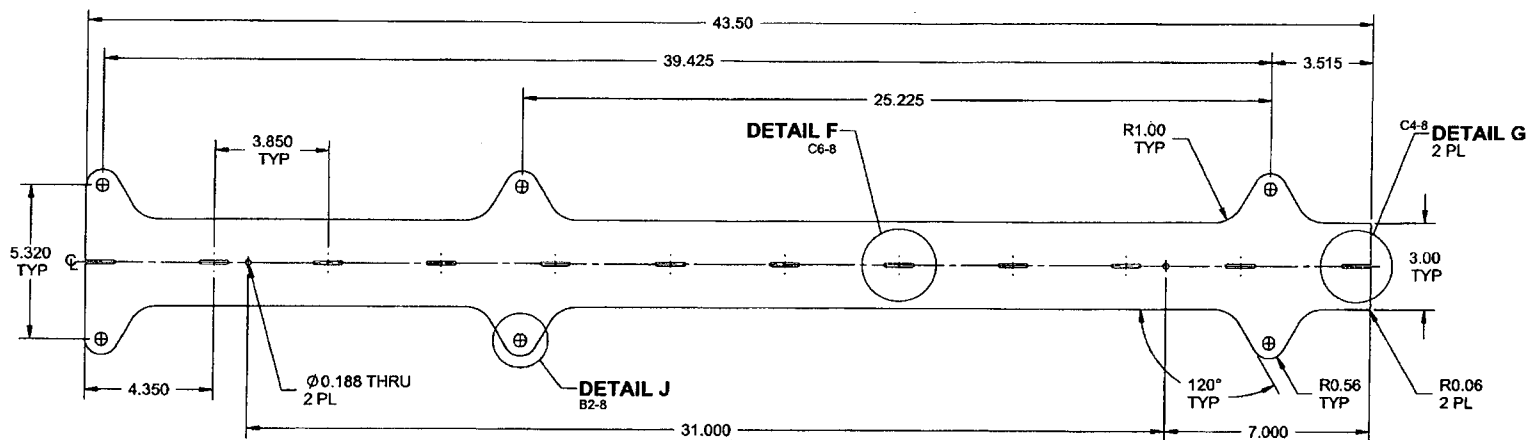
8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



D3805-5 PLATE
(MAKE FROM D3805-5F)



D3805-5F PLATE

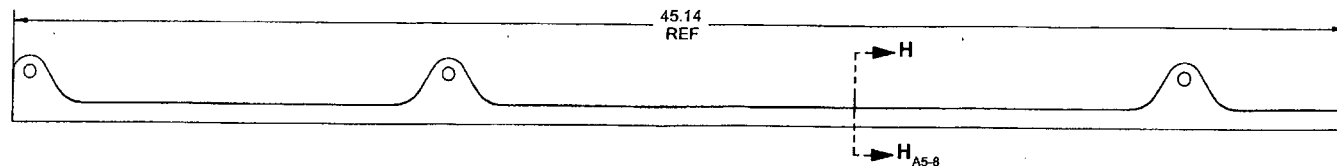
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2011-10-03
MP

NOTES:

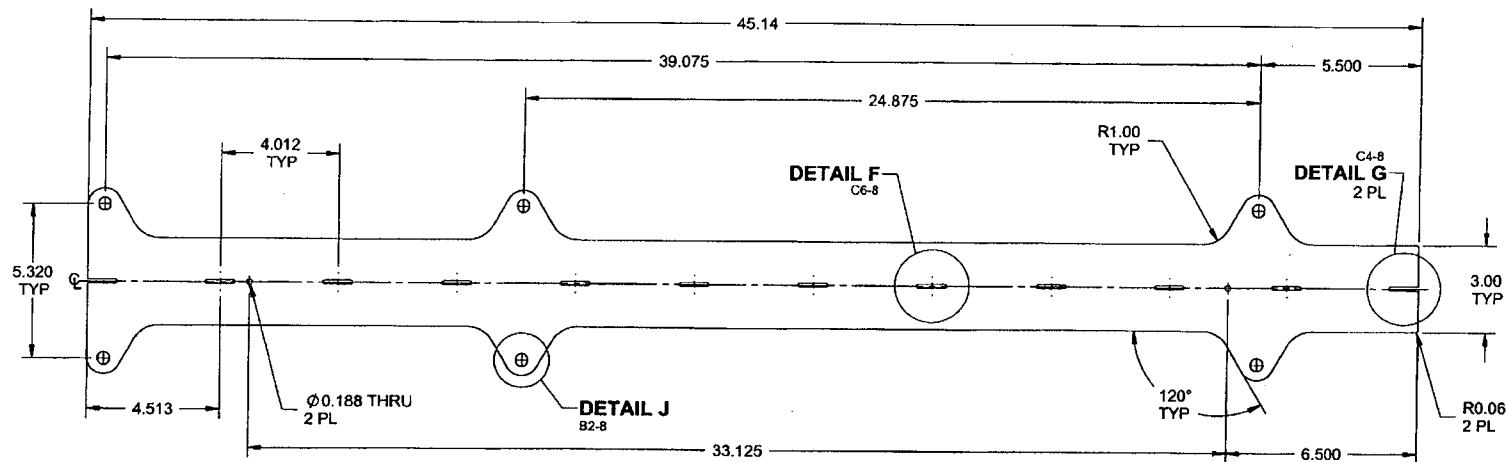
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3805	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE WEARPLATE ASSY	SHEET 6 OF 8
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DE APPR.	<i>[Signature]</i>	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DATE	11.09.16		

8 7 6 5 4 3 2 1



D3805-7 PLATE
(MAKE FROM D3805-7F)



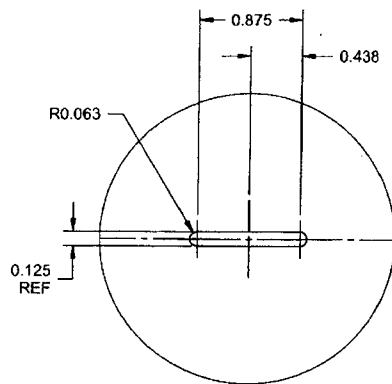
D3805-7F PLATE

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2011-10-03

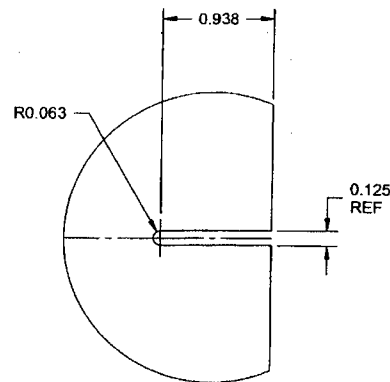
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

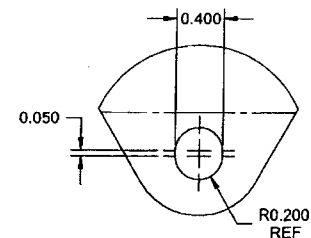
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D3805	REV. B
MFG. APPR.		TITLE	SHEET 7 OF 8
APPROVED		WEARPLATE ASSY	SCALE
DE APPR.			NTS
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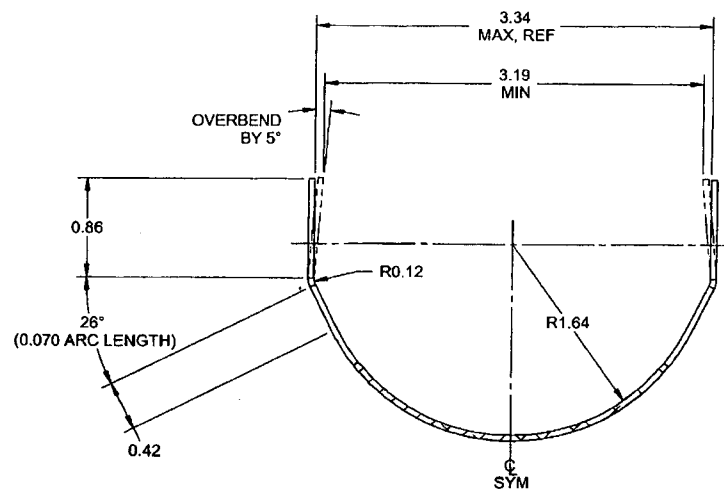
DETAIL F
SLOT DETAIL TYP
SCALE 4X
C5-4
C5-5
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X
B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

RELEASED
2011-10-02

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D3805	REV. B
MFG. APPR.		SHEET 8 OF 8	
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	11.09.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMBINED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	